

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026176**Date Inspected:** 01-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG Components				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Vessel Zhenghua #19

This QA Inspector randomly observed the following on the Vessel Zhenghua #19:

ZPMC workers were observed performing what appeared to be initial tightening and then final tightening of ASTM A325M bolt sets using a pneumatic impact wrench at OBG Segment 13AW/13BW transverse joint, south (crossbeam) side, edge plate stiffeners, panel points 120~120.5. The bolt sets and adjacent steel being bolted showed no turn-of-nut initial tightening markings during or after final tightening.

ZPMC workers were observed performing what appeared to be initial tightening and then final tightening of ASTM A325M bolt sets using a pneumatic impact wrench at OBG Segment 13BW/13CW transverse joint, south (crossbeam) side, edge beam, panel points 122~122.5. The bolt sets and adjacent steel being bolted showed no turn-of-nut initial tightening markings during or after final tightening.

ZPMC workers were observed performing what appeared to be initial tightening and then final tightening of ASTM A325M bolt sets using a pneumatic impact wrench at OBG Segment 13BW/13CW transverse joint, south (crossbeam) side, edge plate, panel points 122~122.5. The bolt sets and adjacent steel being bolted showed no turn-of-nut initial tightening markings during or after final tightening.

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ZPMC workers were observed drilling into splice plates that had been removed from OBG Segment 13BW, location #17~20, side plate stiffeners, 3rd and 4th from edge beam, south (crossbeam) side, between panel points 121~121.5; and splice plates that had been removed from OBG Segment 13CW, location #9~12, bottom plate stiffeners, 1st and 2nd from edge beam, south (crossbeam) side, bottom plate stiffeners, panel points 123~123.5. The approximately 26mm holes were being drilled 7mm to 12mm from originally drilled holes making figure eight shaped elongated holes approximately 33mm to 38mm long. This QA Inspector contacted ZPMC QA Zhang Wei (ZQA) who informed this QA Inspector that he thought that an Caltrans-approved RFI existed concerning this issue and ZQA would present a copy of the RFI to Caltrans QA Inspectors by 0800 hours on 8/2/2011.

This QA Inspector also randomly observed the following on the Vessel Zhenghua #19 in response to a verbal request from ZPMC QA Zhang Wei, Bolting Inspection Notification Sheet Number 00731:

Item 1 - OBG Segment 13E, panel point 120:

No ZPMC workers were observed in the area. This QA Inspector contacted ZQA by phone. ZQA informed this QA Inspector that the inspection request was cancelled.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
